

Ship TODAY 08.12.08 Dart Aerospace Ltd.

Date: Monday, 08/12/2008 1:13:20 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLIP
Job Number	: 43936		
Estimate Number	: 11103		
P.O. Number	:	Part Number	: D30277
This Issue	: 08/12/2008 S.O. No. :	Drawing Number	: D3027 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 43936	Material	:
Written By	: <u>Jan 08.12.08</u>	Due Date	: 15/12/2008 Qty: 8 Um: Each
Checked & Approved By	:		
Comment	: Est. C 05.10.07 Added forming step and Issue P/O KJ/JLM Est Rev:B Now on WaterJet 08-12-08 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.0252 sf(s)/Unit Total : 0.2016 sf(s)

2024-T3 .050 sheet

BATCH: 107711 B 8-12-8

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3027 ***NOTE GRAIN DIRECTION*****

Dwg Rev: B

Prog Rev: B

B 8-12-8

(10)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-12-8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/12/08 (10)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form as per Dwg D3027

Dwg Rev: B

D 08/12/08 (10)

S 08/12/08

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLIP

Job Number: 43936

Part Number: D30277

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/08 (400)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 08/12/08

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-08 (100)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 60

8/12/09 50

10.0

QC21

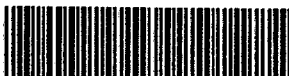
FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/08

Job Completion



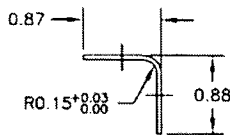
MF 08-12-09



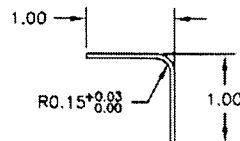
DESIGN RF	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3027	REV. B SHEET 2 OF 2
DATE 05.09.20		TITLE CLIP	SCALE 1:2

RELEASED
05-10-03 *[Signature]*

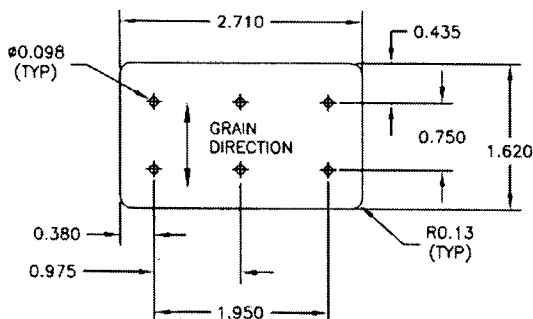
w/o 4393 *[Signature]*



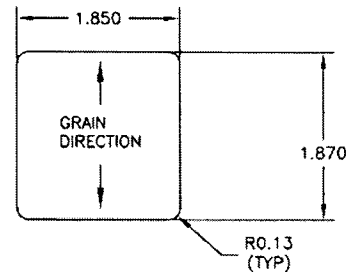
D3027-5 BEND DETAIL



D3027-7 BEND DETAIL



D3027-5 FLAT PATTERN
(0.050" SHEET)



D3027-7 FLAT PATTERN
(0.050" SHEET)

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

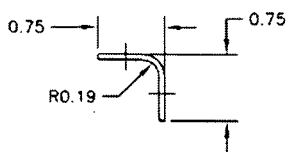
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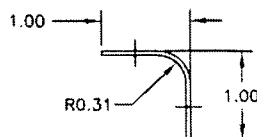


DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3027	REV. B SHEET 1 OF 2
DATE	05.09.20			TITLE CLIP	SCALE 1:2
A	01.05.18			NEW ISSUE	
B	05.09.20			REMOVE HOLES FROM -7	

RELEASED
05-10-03 *[Signature]*

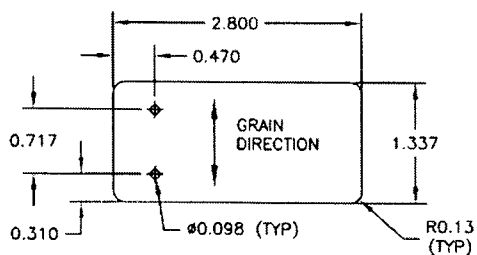


D3027-1 BEND DETAIL

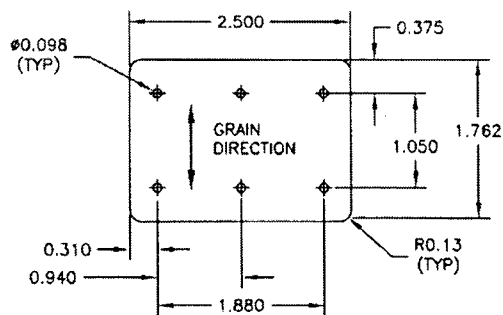


D3027-3 BEND DETAIL

Wb 43936



D3027-1 FLAT PATTERN
(0.063" SHEET)



D3027-3 FLAT PATTERN
(0.050" SHEET)

NOTES:

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- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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